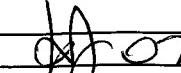


Date: Tuesday, 8/21/2007 3:43:55 PM
 User: Kim Johnston

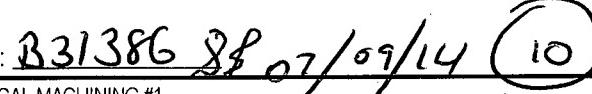
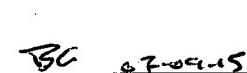
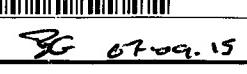
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW		
Job Number	: 34195					
Estimate Number	: 12933					
P.O. Number	: N/A			Part Number	: D29392UP	
This Issue	: 8/21/2007 S.O. No. : N/A			Drawing Number	: D2939 REV C	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: N/A			Material	: N/A	
Written By	:  07.08.22			Due Date	: 9/20/2007	
Checked & Approved By				Qty:	10	
Comment	: Est Rev:A New Issue 07-07-04 JLM			Um:	Each	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	7075-T7351 2X6X6.25	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No:  10	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: OK 9/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:55 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER
REVIEW

Job Number: 34195

Part Number: D29392UP

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1.
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
8.0	PACKAGING 1	PACKAGING RESOURCE #1
9.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



W 09/09/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34195
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.124	.124	.124		
B	0.100	0.140		.124	.124	.124	.124		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.220	.220	.220	.220		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.580	1.580	1.580	1.580		
J	2.495	2.505		2.504	2.500	2.500	2.500		
K	0.257	0.262		.259	.259	.259	.259		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.552	.552	.552	.552		
P	0.490	0.510		.500	.504	.504	.504		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.143	.143	.143	.143		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.369	1.369	1.369	1.369		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.258	1.258	1.258	1.258		
Y	1.565	1.585	DT8695 A/B	1.573	1.573	1.573	1.573		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	8.18	Audited by:	<i>Amel</i>
Date:	07/09/14	Date:	07/09/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JK</i>	<i>JLM</i>

DART AEROSPACE LTD	Work Order:	34195
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	A ₄	A ₆	A ₇	A ₈	By	Date
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.127	.127	.127	.127		
C	0.100	0.140		.115	.115	.115	.115		
D	0.210	0.230		.221	.221	.221	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.239	.239	.239	.239		
N	0.100	0.140		.122	.122	.122	.122		
O	0.540	0.560		.554	.554	.554	.554		
P	0.490	0.510		.508	.508	.508	.508		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.252	.252	.252	.252		
T	0.100	0.180		.150	.150	.150	.150		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.319	.319	.319	.319		
X	1.250	1.270		1.262	1.262	1.262	1.262		
Y	1.565	1.585	DT8695 A/B	1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:		Audited by:	
Date:	07/09/15	Date:	07/09/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

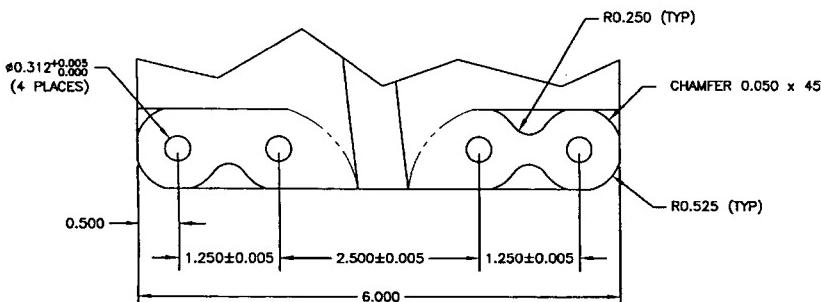
DART AEROSPACE LTD	Work Order:	34195
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X	2	3	4	By	Date
A	0.100	0.140		.125	.125				
B	0.100	0.140		.127	.127				
C	0.100	0.140		.115	.115				
D	0.210	0.230		.221	.221				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.510	.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.239	.239				
N	0.100	0.140		.122	.122				
O	0.540	0.560		.554	.544				
P	0.490	0.510		.508	.508				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.745	2.745				
S	0.240	0.270		.252	.252				
T	0.100	0.180		.150	.150				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.319	.319				
X	1.250	1.270		1.262	1.262				
Y	1.565	1.585	DT8695 A/B	1.575	1.575				
Z	0.178	0.198		.185	.185				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

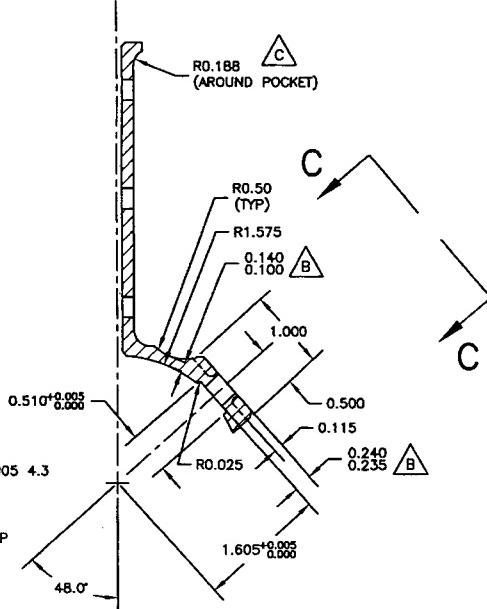
Measured by:	<i>RF</i>	Audited by:	<i>JLM</i>
Date:	07/04/15	Date:	07/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>JLM</i>	<i>JLM</i>



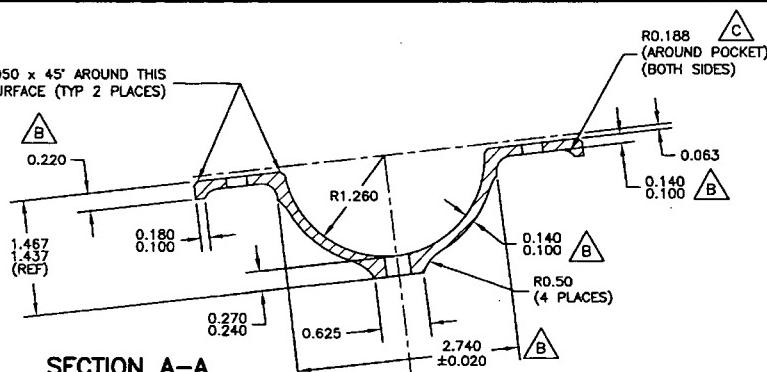
VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

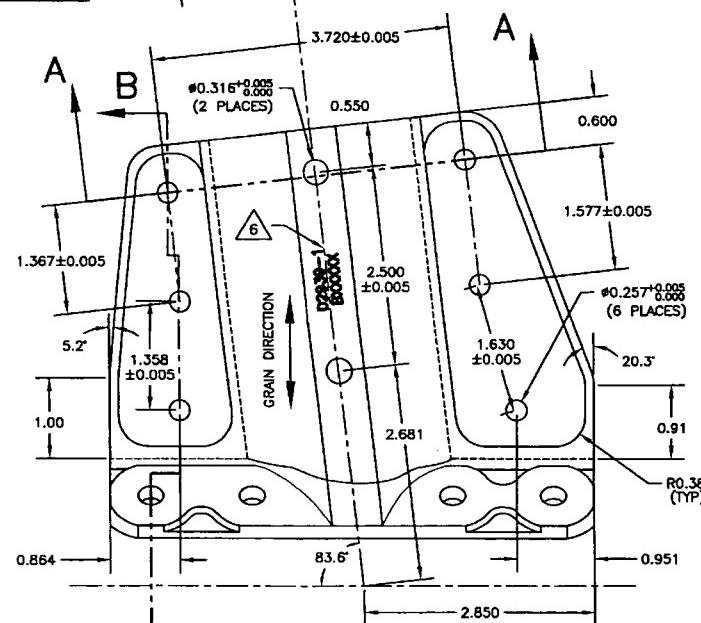


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



B

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	4	DRAWN BY CB DART DART AEROSPACE USA, INC. REVIEWED BY APPROVED DATE 06.11.09
CHECKED	PW	DRAWING NO. D2939 SHEET 1 OF 1
DATE		TITLE SADDLE INSIDE

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